

Work Order ID **56401**

February 22, 2010 2:07:56 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4001-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Filler Flange

Start Date: 22/02/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 25/02/2010 Req'd Qty: 2.00

Customer:

Reference:

10-02-22

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4001

~~A PRELIM~~ *Rev. A*

Rev. A

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

cut blank 4.200" long

MMZ 10/08/23
MMZ 10/03/01

(TOTAL 4 BLANKS)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA912

FOLIO REV: *A Prelim*

DWG REV: *A*

DEBURR

MMZ 10/08/24
MMZ 10/03/01

5

Work Order ID 56401

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Page 2

Item ID:	D4001-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fuel Filler Flange					
Start Date:	22/02/2010	Start Qty: 2.00		Cust Item ID:		
Required Date:	25/02/2010	Req'd Qty: 2.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
140 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							

QC APPROVAL

10.04.13

(2)

10.6.15 SP 2X

not inspector to
Release Day.

8/10/03/04 10 p.m. Day only
no changes from PA Day to Res A Day.
8/10.4/22

Pro →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4001-1 PAR #: _____ Fault Category: prelim set-up stage NCR: Yes ☒ No ☐ DQA: [Signature] Date: 10.06.10
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>56401</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/24	110	During inspection Found the parts are too thin. 0.71" ± 0.00 d.m is measuring .588" + 0.015 max R.C. Program error	[Signature]	-Scrap + Destroy Qty +2 AND replace M <u>107221</u> +2	[Signature] 10/03/01	S 10/03/04	[Signature]	S 10/02/24
			[Signature]	-Fix Program	[Signature] 10.02.24	S 10/03/04	[Signature]	S 10/02/24

NOTE: Date & initial all entries

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Item ID: D4001-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Filler Flange

Start Date: 22/02/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 25/02/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/15 *[Signature]*B10-4-14
(2)

POSITIVE RECALL

EFFECTIVE *10.2.12*AUTH *[Signature]*RELEASED *[Signature]*DATE *10.06.04*Qty *1**[Handwritten signature]*

Picklist Print

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Page 1

Work Order ID: 56401



Parent Item: D4001-1



Parent Item Name: Fuel Filler Flange

Start Date: 22/02/2010

Required Date: 25/02/2010

Comments: IPPP REV.A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M606116B1.000X04.00		Purchased	No			100	f	68.5000	0.7371			



6061-T6 Bar 1.00 x 4.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

68.5

107221

62.27

8803

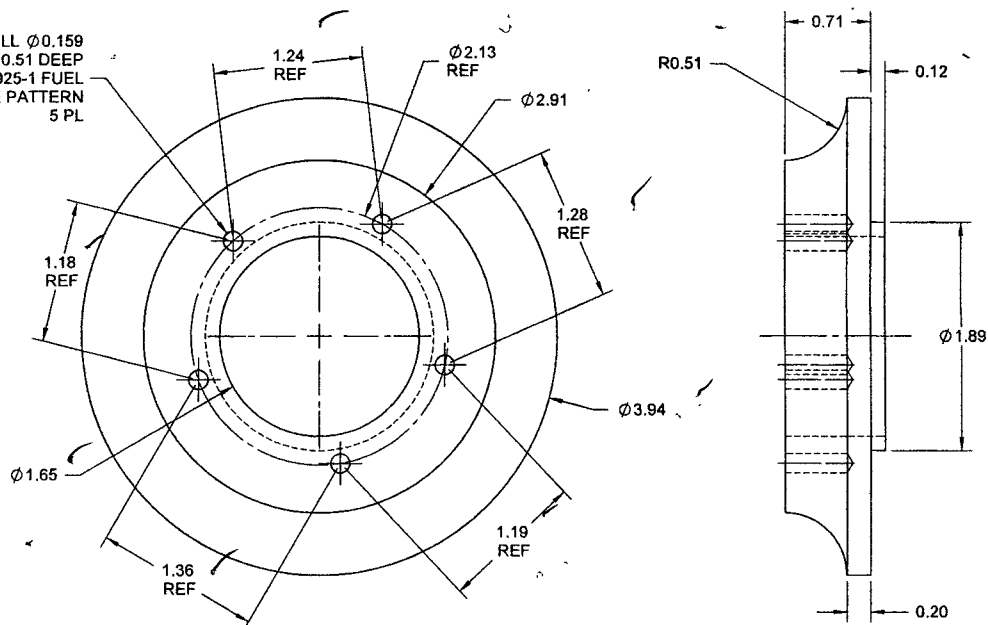
6.23

MNF 10/02/25 2.7371 + .7371

MNF 10/03/26

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-1	JCA-M47-1-08

DRILL $\phi 0.159$
TAP 10-32 UNF X 0.51 DEEP
SPACED TO MATCH D4025-1 FUEL
SENDER UNIT HOLE PATTERN
5 PL



W/O 56401

See Rev. A

D4001-1 FITTING

PRELIMINARY ISSUE
10.02.05

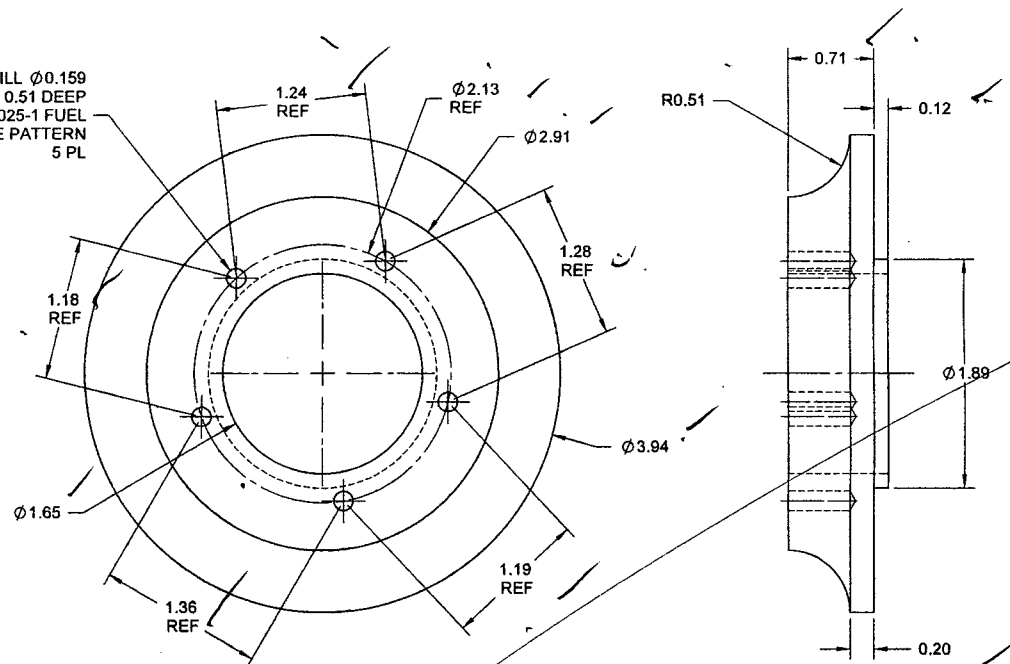
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

PA2	NEW ISSUE		10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		
		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. PA2
		D4001	SHEET 1 OF 2
		TITLE	SCALE
		FITTING	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-1	JCA-M47-1-08

DRILL $\varnothing 0.159$
TAP 10-32 UNF X 0.51 DEEP
SPACED TO MATCH D4025-1 FUEL
SENDER UNIT HOLE PATTERN
5 PL



D4001-1 FITTING

NOTES:

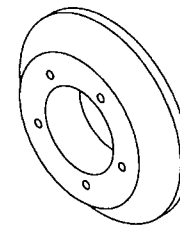
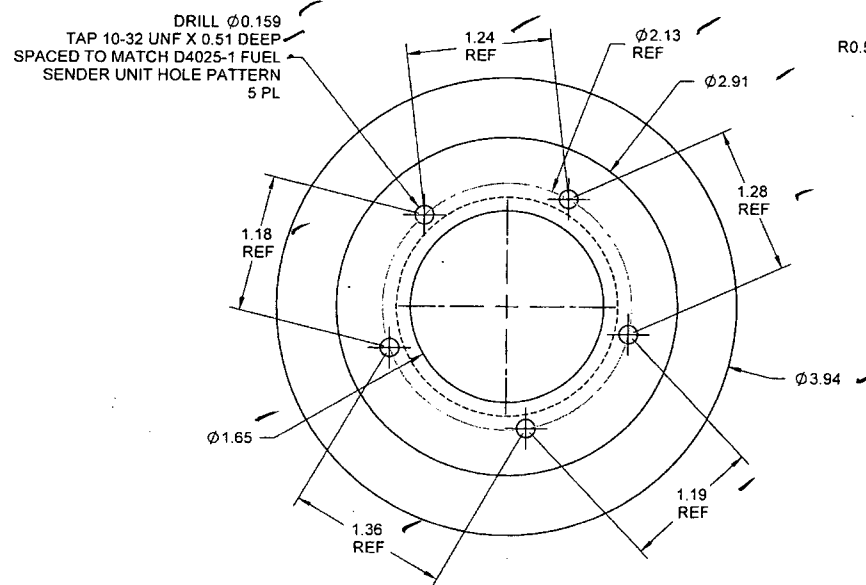
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PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.02.05			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4001	SHEET 1 OF 2
TITLE FITTING	SCALE NTS

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-1	JCA-M47-1-08



W/0 56401

D4001-1 FITTING

RELEASED
R 2010-05-05
AM

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR-
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
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DESIGN				
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MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.02.05			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D4001**
REV. A
SHEET 1 OF 2
TITLE **FITTING**
SCALE NTS

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